

## CLAIMS

1. A packaging container characterized by comprising:  
(a) a container body formed from a packaging material; and  
(b) a cap unit attached to a cap attachment portion of a top wall of said container body, wherein

(c) said cap unit includes a collar portion; a pull tab adapted to cover, from an outer side of the packaging material, a discharge opening portion defined on the packaging material to correspond to the cap attachment portion; an inner tape adapted to cover the discharge opening portion from a reverse side of the packaging material; and a lid portion adapted to be fitted into said collar portion via the pull tab.

2. A packaging container according to claim 1, wherein a punched hole is formed in the discharge opening portion.

3. A packaging container according to claim 1, wherein a thin wall portion is formed in the discharge opening portion.

4. A packaging container characterized by comprising:  
(a) a container body formed from a packaging material; and  
(b) a cap unit attached to a cap attachment portion of a top wall of said container body, wherein

(c) said cap unit includes a pull tab adapted to cover, from an outer side of the packaging material, a discharge opening portion defined on the packaging material to correspond to the cap attachment portion; an inner tape adapted to cover the discharge opening portion from a reverse side of the packaging material; and a lip which partially

surrounds the discharge opening portion and is welded to the top wall via the pull tab.

5. A packaging container characterized by comprising:

(a) a container body;

(b) a lip fixed to a top wall of the container body and having a thick portion which partially surrounds a discharge opening portion and which does not have a lid; and

(c) a pull tab bonded to a portion of the packaging material forming the top wall such that the pull tab covers the discharge opening portion from an outer side of the packaging material.

6. A packaging container according to claim 5, further comprising an inner tape which is bonded to the packaging material from a reverse side thereof.

7. A packaging container according to claim 5, wherein the lip includes an outer patch seal, and the thick portion is formed on the outer patch seal through injection molding.

8. A packaging container according to claim 7, wherein the outer patch seal has a body portion bonded to the top wall and a skirt portion bonded to a front wall.

9. A packaging container according to claim 5, wherein the thick portion of the lip is formed through thermal deformation of a film.

10. A method of manufacturing a packaging container characterized by comprising:

(a) a cap attachment step of attaching a cap onto a cap attachment portion of a packaging material before being subjected to

forming;

(b) a forming step of forming the packaging material, on which the cap has been attached, into a predetermined shape; and

(c) a charging step of charging a liquid food into the formed packaging material.

11. A method of manufacturing a packaging container according to claim 10, wherein

(a) the packaging material has a web-like shape before being subjected to forming; and

(b) the packaging material on which the cap has been attached is formed into a tubular shape.

12. A method of manufacturing a packaging container according to claim 10 or 11, wherein

(a) the cap has a collar portion and a lid portion and can be brought into an opened state and a closed state; and

(b) the cap attachment step includes the steps of: fixing the cap onto the packaging material; bringing the cap into an opened state; punching a hole in the packaging material; welding an inner tape onto a reverse surface of the packaging material and a pull tab onto an outer surface of the packaging material in order to cover an area surrounded by the collar portion; welding together the inner tape and the pull tab to thereby form a rupture portion; and fitting the lid portion into the collar portion.

13. A method of manufacturing a packaging container according to any one of claims 10 to 12, wherein

(a) the cap has a collar portion;

(b) the cap attachment step includes the steps of: punching a hole in the packaging material; welding an inner tape onto a reverse surface of the packaging material and a pull tab onto an outer surface of the packaging material in order to cover an area surrounded by the collar portion; and welding together the inner tape and the pull tab to thereby form a rupture portion.

14. A method of manufacturing a packaging container according to any one of claims 10 to 13, wherein

(a) a thin wall portion is formed in advance in the packaging material before the packaging material is subjected to forming;

(b) the cap has a collar portion and a lid portion and can be brought into an opened state and a closed state; and

(c) the cap attachment step includes the steps of: fixing the cap onto the packaging material such that the cap faces the thin wall portion; bringing the cap into an opened state; welding a pull tab onto an outer surface of the packaging material in order to cover an area surrounded by the collar portion; and fitting the lid portion into the collar portion.

15. A method of manufacturing a packaging container according to any one of claims 10 to 14, wherein

(a) a thin wall portion is formed in advance in the packaging material before the packaging material is subjected to forming;

(b) the cap has a collar portion;

(c) the cap attachment step includes the steps of: fixing the

cap onto the packaging material such that the cap faces the thin wall portion; and welding a pull tab onto an outer surface of the packaging material in order to cover an area surrounded by the collar portion:

16. A method of manufacturing a packaging container according to any one of claims 10 to 15, wherein

(a) the cap has a lip; and

(b) the cap attachment step includes the steps of: punching a hole in the packaging material; welding an inner tape onto a reverse surface of the packaging material and a lip onto an outer surface of the packaging material via a pull tab and at the same time welding together the inner tape and the pull tab to thereby form a rupture portion.

17. A method of manufacturing a packaging container characterized by comprising the steps of:

(a) fixing a lip onto a packaging material;

(b) forming a discharge opening portion in at least the lip; and

(c) bonding a pull tab to the outer surface of the packaging material in order to cover the discharge opening portion.

18. A method of manufacturing a packaging container according to claim 17, wherein an inner tape is bonded to the reverse surface of the packaging material.